

Rush

Work Order ID 64748

Wednesday, December 15, 2010 1:26:57 PM



Page 1

Item ID: D3564-3

Accept



Setup Start



Revision ID:

Item Name: Wearshoe

Stop



Start Date: 12/15/2010 Start Qty: 10.00



Cust Item ID:

Required Date: 12/17/2010 Req'd Qty: 10.00



Customer:

Reference:

Approvals:

Process Plan: *PL*

Date: *12/15*

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

Draw Nbr

Revision Nbr

D3564

Rev D

100

0.00



FLOW WATER JET

Waterjet

Memo

0.00

FLOW CNC Waterjet

1-Cut as per Dwg D3564 ***** (D3564-1F)***** Dwg Rev: *D* Prog
Rev: *D* 2-Deburr if necessary

12/10-12-15

(14)

110

QC2- Inspect parts off machine FAI/FAIB

0.00

QC

Memo

0.00

Quality Control

12/10-12-15

120

QC8- Inspect parts - second check

0.00

QC

Memo

0.00

Quality Control

12/10-12-16

(14)

Work Order ID 64748

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Stop



Start Date: 12/15/2010 Start Qty: 10.00



Cust Item ID:

Required Date: 12/17/2010 Req'd Qty: 10.00



Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

130



NC BRAKE

Brake NC

Memo

0.00

0.00

Brake NC

Deburr if necessary Form on Brake as per Dwg D3564 using Jigs DT8179 and DT8155 Form Joggle as per Dwg D3564 on brake using Jig DT8157

SP 10/12/17

140



QC5- Inspect part completeness to step on W/O

0.00

QC

Quality Control

Memo

0.00

Ensure joggle as per dwg D3429

10/12/17

150



Large Fab

0.00

Large Fab

Memo

0.00

Large Fab

Qty Description Batch A/R
M116359 Weld hardcoat as per Dwg D3437

EL 10-12-20 X13
pfo
Last page

Work Order ID 64748

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Wednesday, December 15, 2010 1:26:57 PM

Item ID: D3564-3

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Setup Start



Revision ID:

Item Name: Wearshoe

Stop



Start Date: 12/15/2010 Start Qty: 10.00



Cust Item ID:

Required Date: 12/17/2010 Req'd Qty: 10.00



Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

160



QC

Quality Control

QC10- Inspect visual per QSI004- ground welds

0.00

S. W. H. W.

0.00

(413)

170



QC

Quality Control

QC5- Inspect part completeness to step on W/O

0.00

S. W. H. W.

0.00

(413)

180



Powdercoat

Powder Coating

Grey Sandtex(Ref:4.3.5.6) per QSI005 4.3

0.00

112888

Memo

0.00

START TIME:

3:20

1:55

OVEN TEMPERATURE:

2.25

13 10/12/2011

Work Order ID 64748

Wednesday, December 15, 2010 1:26:57 PM



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Item ID: D3564-3

Accept



Setup

Start



Revision ID:

Item Name: Wearshoe

Stop



Start Date: 12/15/2010 Start Qty: 10.00



Cust Item ID:

Required Date: 12/17/2010 Req'd Qty: 10.00



Customer:

Reference:

Approvals: Process Plan: _____

Date: _____

Tooling: _____

Date: _____

Run

Start



QC: _____

Date: _____

SPC (Y/N): _____

Date: _____

Stop

Sequence ID/
Work Center ID

190



QC

Quality Control

Operation
Description

QC3- Inspect Part Finish

Set Up/
Run Hours

0.00

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

200



Packaging

Packaging

Identify as per dwg & Stock Location:

FP:19

0.00

10/12/21 SF 13SF

210



QC

Quality Control

QC21- Final Inspection - Work Order Release

0.00

Memo

0.00

13 BL 10-12-21.

OK 10/12/22

PL 10-12-22

(14)

Picklist Print

Page 1

Wednesday, December 15, 2010 1:27:02 PM

Work Order ID: 64748



Parent Item: D3564-3



Parent Item Name: Wearshoe

Start Date: 12/15/2010

Required Date: 12/17/2010

Start Qty: 10.00

Required Qty: 10.00

Comments: IPP Rev:A New Issue 07-03-08 ec
IPP Rev:B As per Rev C 07-07-09 JLM
IPP Rev:C As per Rev D 07-09-09 JLM Verified By:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M304S16GA		Purchased	No			100	sf	113.0000	1.1	11.57895			

304/316 Sheet .063



<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>
MAT	113	
111323	0	
115953	113	115953

HB 10-10-15

(14)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
10/12/26	150	took ① plate for testing alternate possible welding rod.	Q	10-12-20	1	U 10/12/21	S 10/12/21

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART AEROSPACE LTD	Work Order:	141748
Description: Wearshoe	Part Number:	D3564-3
Inspection Dwg: D3564	Rev: D	Page 1 of 1

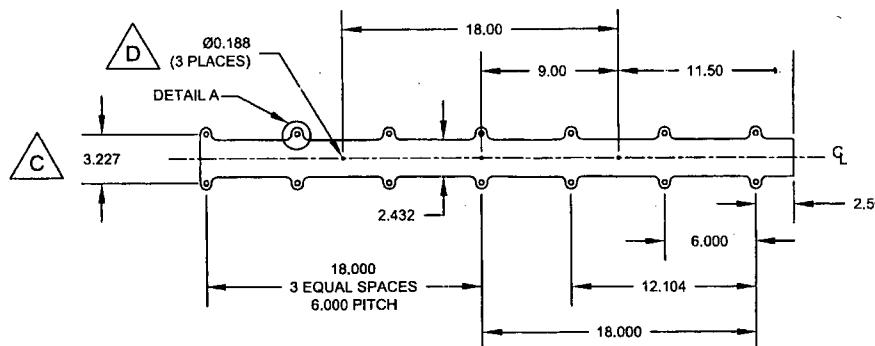
FIRST ARTICLE INSPECTION CHECKLIST

X First Article Prototype

Measured by: B	Audited by: S	Prototype Approval: N/A
Date: 10-12-15	Date: 10/12/16	Date: N/A

Rev	Date	Change	Revised by	Approved
A	07.09.06	New Issue	KJ/JLM	
B	08.09.04	Dwg Rev updated	KJ/DD	

8 7 6 5 4 3 2 1



SHOP COPY

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SUBJECT TO AMENDMENT

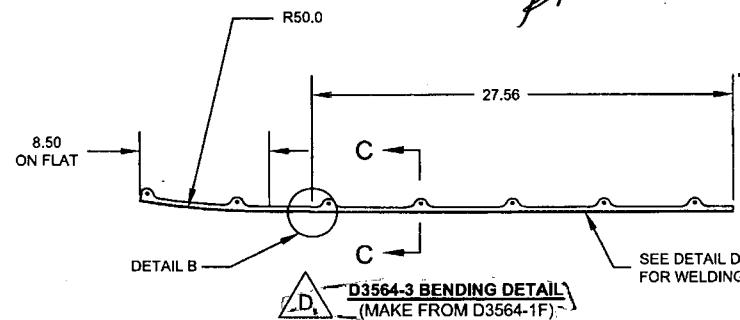
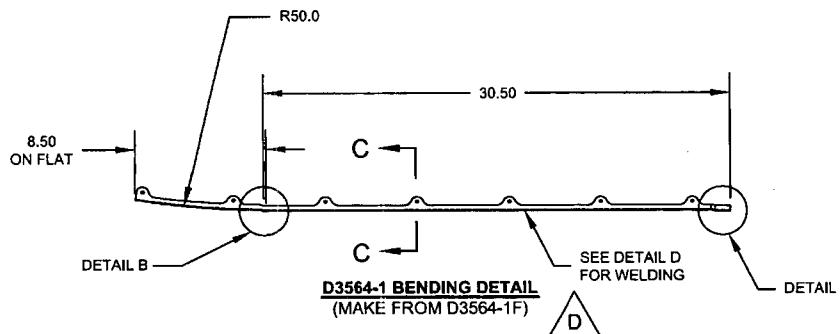
WITHOUT NOTICE

WORK ORDER

NO. 64748

PL/012-15 RELEASED

07.09.04

**D3564-1/-3/-5/-7/-9/-11/-13/-15 WEARPLATE NOTES:**

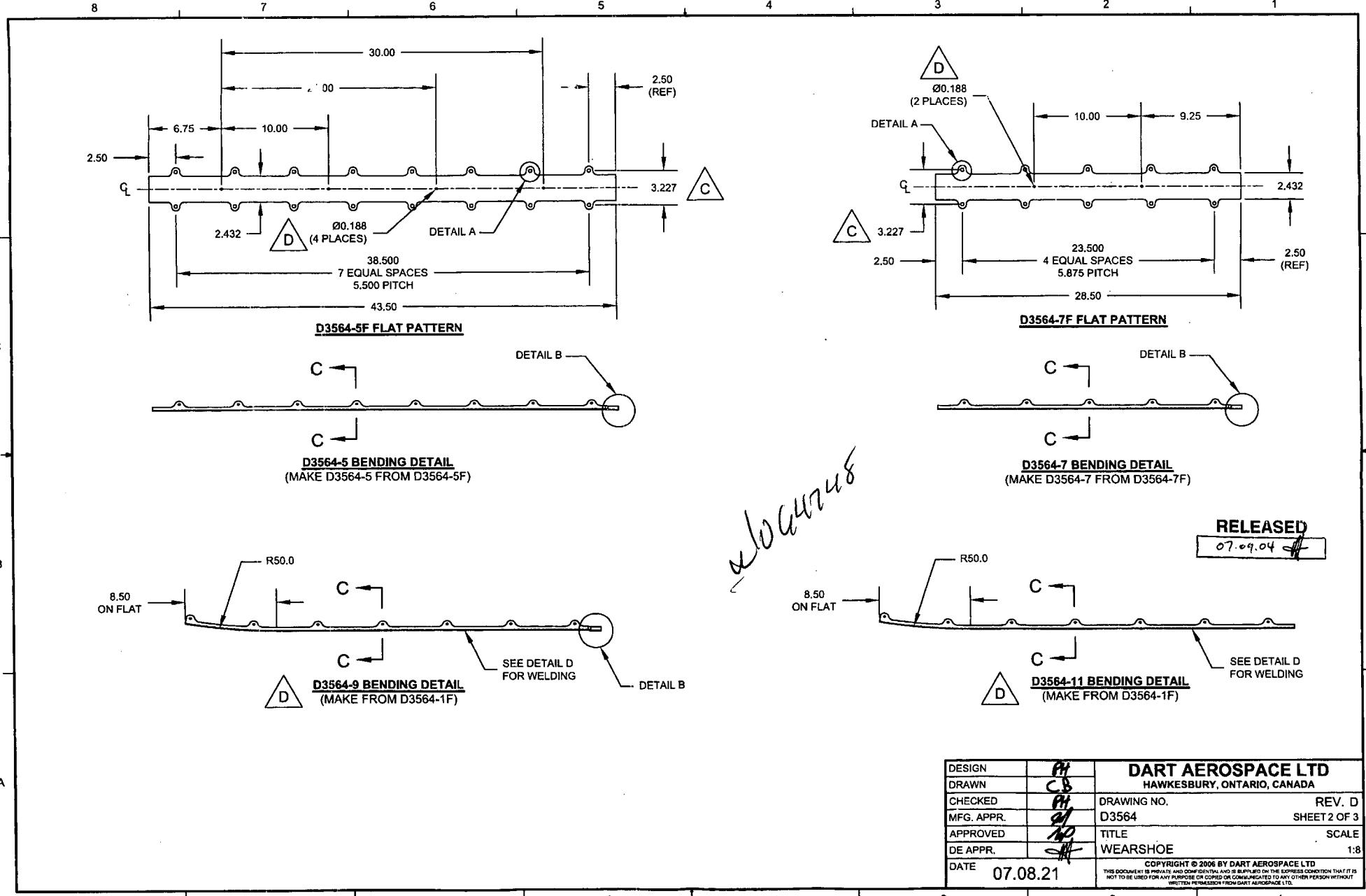
- 1) MATERIAL: AISI 304/316 SS SHEET PER AMS 5513 OR AMS 5524, 16 GAUGE (0.063 THICK)
(REF DART MATERIAL SPEC M304S16GA)
- 2) FINISH: POWDER COAT GREY SANDTEX (REF 4.3.5.6) PER DART QSI 005 4.3
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.015 MAX
- 6) IDENTIFICATION: NONE
- 7) WEIGHT: SEE TABLE IN ZONE A3
- 8) WELD PER DART QSI 004
- 9) SEE PG 3 FOR SECTIONS AND DETAILS
- 10) PARTS ARE SYMMETRIC ABOUT \varnothing

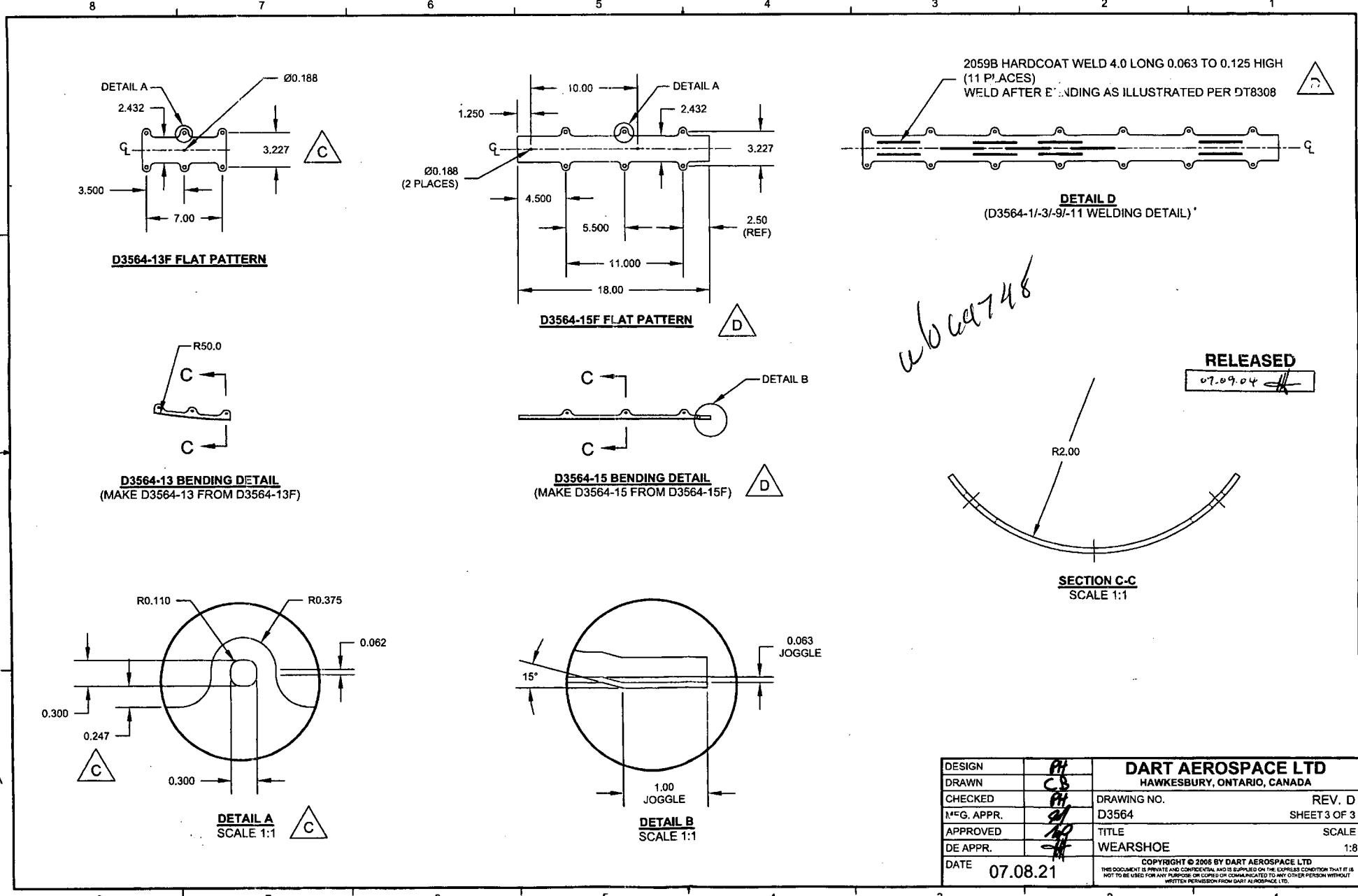
WEIGHTS:	
D3564-1	1.85 lbs
D3564-3	1.85 lbs
D3564-5	1.93 lbs
D3564-7	1.26 lbs
D3564-9	1.85 lbs
D3564-11	1.85 lbs
D3564-13	0.38 lbs
D3564-15	0.80 lbs

REV.	DESCRIPTION	BY	DATE
D	UPDATE DRAWING TEMPLATE; CHANGE ALL (TYP X PLS) TO (X PLACES); PG1 A8: UPDATE NOTES; PG1 A8, PG3 B5,C5: ADD D3564-15; PG1 B6,B3; D3564-1/-3 WAS ONE FIGURE; PG2 A7,A3; D3564-9/-11 WAS ONE FIGURE; PG2 A7,A3; D3564-9/-11 WAS ON PG1; PG3 B8,C9; D3564-13 WAS ON PG2; PG3 D2: WELDING DETAIL WAS ON PG1 PG3 A5,7,B2: RELOCATE DETAILS AND SECTION; PG3 A5,7,B2: INCREASE DETAIL AND SECTION SIZE	CB	07.08.21
C	MOVE TAB OUTBOARD, DETAIL A	PH	07.04.17
B	ADD AMS 5513 AND AMS 5524	PH	07.03.20
A	NEW ISSUE	PH	06.12.18
DESIGN	PH	DART AEROSPACE LTD	
DRAWN	CB	HAWKESBURY, ONTARIO, CANADA	
CHECKED	PH	DRAWING NO.	REV. D
MFG. APPR.	SI	D3564	SHEET 1 OF 3
APPROVED	SI	TITLE	SCALE
DE APPR.	SI	WEARSHOE	1:8
DATE	07.08.21		

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8 7 6 5 4 3 2 1





DESIGN	PH	DART AEROSPACE LTD
DRAWN	CB	HAWKESBURY, ONTARIO, CANADA
CHECKED	PH	DRAWING NO. D3564
MFG. APPR.	PH	REV. D
APPROVED	PH	SHEET 3 OF 3
DE APPR.	PH	TITLE WEARSHOE
DATE	07.08.21	SCALE 1:8

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